	Work Order ID 66591  Tuesday, February 22, 2011 1:14:50 PM								,		Page	
Item ID: Revision ID: Item Name:  Start Date: Required Date: Reference:	D3520-3 Spacer 2/22/2011 2/25/2011	Start Qty: 12.00 Req'd Qty: 12.00		Accept	Cust Item II				Setup	Start Stop	1 18811181 81	
Approvals:		an: MW	Date: 11-02-32	Tooling: SPC (Y/N):		te:			Run	Start Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
Draw Nbr D3520	Re B	vision Nbr	•							,		
Doosan Lathe		DWG REV: FOLIO REV		0.00	//		<u> </u>	12		J		
110                                  OC		2-Deburr  QC2- Inspect parts off m.	achine FAI/FAIB	0.00				12				

e) 11/3/(

Memo

Quality Control

## **Dart Aerospace Ltd**

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W/O:	STEP	PR	OCEDURE CHAI	RK ORDER CHANC		Ву	Date	Qty	Approval Chief Eng /	Approval			
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Part No: PAR #: Resolution:			Fault Cated	Jory:	NCR	: Yes I	Vo <b>DQ</b>						
			Disposition	າ:	QA:	N/C Clo	sed:		Date: _				
NCR:			WORK ORDI	R NON-CONFORM	IANCE	(NCR	)						
		Description of NC		Corrective Action Sec	ction B		Verifi	fication Approval App					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		tion C	Chief Eng	QC Inspector			
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#### Work Order ID 66591

Tuesday, February 22, 2011 1:14:51 PM



Page 2

Item ID:

D3520-3

Accept

Setup Start



**Revision ID:** 

Item Name: **Start Date:** 

Spacer

2/22/2011

**Start Qty: 12.00** Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Run

Start

Stop



Required Date: 2/25/2011

QC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool # Plan

Code

Stop

Reject

Qty



Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID** 

QC

Quality Control

Operation Description

Memo

QC8- Inspect parts - second check

0.00

0.00

and 11/03/02

150

HandFinish

Hand Finishing \*

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Accept

Qty

m/ 11/02/02

160 🔍

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

) m-L 11/03/02

<b>Dart Aerospac</b>	e Ltd	
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	Johann			•						
W/O:			W	ORK ORDER CHANG	ES					
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	Re	esolution:	Disposition	on:	QA: N/	C Clos	sed:		Date: _	
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DATE	STEP	Description of NC		tion B	verifica			Approval	Approval	
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section C		Chief Eng	QC Inspector
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Page 3

Tuesday, February 22, 2011 1:14:51 PM

Required Date: 2/25/2011

Item ID:

D3520-3

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Spacer

2/22/2011

**Start Qty: 12.00** 

Reg'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_ Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

170

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Number Stamp

180

HandFinish

Hand Finishing

Quality Control

HandFinishing Memo

Memo

Install Inserts as per Dwg D3488

0.00

-03-03

QC5- Inspect part completeness to step on W/

A

0.00

Dan Aerospace Lio	Aerospace Ltd
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W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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		Gection A	Chief Eng	Chief Eng		Date	Jeci		Officer Eng	QO Mapector				
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#### Work Order ID 66591

Required Date: 2/25/2011

Tuesday, February 22, 2011 1:14:51 PM



Page 4

Item ID:

D3520-3

Accept

Setup Start

Stop



Revision ID:

Item Name: Start Date:

Spacer

2/22/2011

**Start Oty: 12.00** 

Reg'd Otv: 12.00

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

OC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/

Work Center ID

200

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

**Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Reject Insp. Number

Stamp

Packaging

Memo

Memo

0.00

210

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

0.00

11/03/04X

<b>Dart Aerospace</b>	L	td
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W/O:	<del>.</del>		W	ORK ORDER CHANG	ES				121
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DATE	STEP	Description of NC	Description of NC Corrective Action		on B	Verific	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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### **Picklist Print**

Tuesday, February 22, 2011 1:14:47 PM

Work Order ID: 66591

Parent Item:

D3520-3

Parent Item Name: Spacer



Start Date: 2/22/2011

Required Date: 2/25/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			100	f	27.6140	0.03	0.378947			
										13	11	/ マ /	)

<b>Location</b>	Loc Qty	Loc Code	
MAT	25.434		
115609	1.434		<u> </u>
<del>-116406</del>	24		· A 17+
MAT013	2.18		
108876	1.88		
113457	0.3		

Dart Aero	ospace	Ltd
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W/O:				WORK ORDER	CHANGES					
DATE	STEP		PROCEDURE	CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		4.								
Part No	;	PAR #	:: Fault	Category:	NCI	R: Yes I	No <b>DQ</b>	<b>A</b> :	Date:	
Resolution:			Disposition: QA: N/C Closed: _							
NCR:		·	WORK O	RDER NON-CO	NFORMANCE	(NCR	)			
DATE	OTED	Description of N	ıc	Corrective Act			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief En	1 · · · · · · · · · · · · · · · · · · ·				ion C Chief Eng		QC Inspector
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DART AEROSPACE LTD	Work Order: 66591
Description:	Part Number: 13670-3
	D
Inspection Dwg: \ 3<20 , Rev: \	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

	X First Article X Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments		
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008.6	4.015	1.7195				/		
.100	±.010	105						
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Measured by:	[[2	Audited by:	and	Prototype Approval:	
Date:	11/3/1	Date:	11/03/02	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Ø0.800<sup>+0.015</sup> Ø0.323 - 0.100

D3520-3 SPACER

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/14128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6R
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

D

DESIGN	RF	DART AEROSPACE	LTD					
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA						
CHECKED	*/	DRAWING NO.	REV. B					
MFG. APPR.	Chil	D3520	SHEET 2 OF 2					
APPROVED	100	TITLE	SCALE					
DE APPR.		(A119 BASKET) SPACER	NTS					
DATE 10	11 11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND CONFIDENTIAL HIGH SUPPLET ON THE EXPRESS CONDITION THAT IT IS						

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W/O:			WORK ORDER CHANGES									
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